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CHUCK
D5149-7TRN
Job Sheet 201969



Part No: D5149-7TRN

Job Qty: 20 pcs

Part Name: Aft Step Base Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/25/19

Description:

Type: SOLD

Note: DWG REV D SHEET 10 IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	20 pcs	11/25/19	11/25/19	1.00	10.00	Doosan - 1	<i>[Signature]</i> 11/11/21
110	QC 2	20 pcs	11/25/19	11/25/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	<i>JRD</i> 11/11/21

120 QC 8

20 pcs

11/25/19

0.00 0.00

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

QC 8 - 76

QC 8 - 61

DAS
52
9-89

18/4/25

130 Packaging 3-1 - Stock - B4B 20 pcs

11/25/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	20 pcs	11/25/19	0.00	0.00	QC 21 - SA - 21	BAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	2-89

Part Op 100 - Doosan Lathe - Turn blank as per Folio FB356

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock Location: LOCATION: MAT080

140 - QC21- Final Inspection - Work Order Release

NOV 25 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.250	6061-T6 Round Bar 3.250"	8.3200 ft (.416 ea) 8,5729	100-Doosan - 1	5230645

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R3.250	8	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Aft Step Base	3.232Inches + 0.012 - 0.001	3.244 3.231	3.232	
2	Aft Step Base	2.875Inches + 0.012 - 0.001	2.887 2.874	2.88	
3	Aft Step Base	0.032Inches ± 0.010	0.042 0.022	R1/32	Radius
4	Aft Step Base	0.060Inches ± 0.010	0.070 0.050	0.064	
5	Aft Step Base	0.060Inches ± 0.030	0.090 0.030	0.06 F	
6	Aft Step Base	0.875Inches ± 0.010	0.885 0.865	0.877	
7	Aft Step Base	3.190Inches ± 0.030	3.220 3.160	3.191	
8	Aft Step Base	4.000Inches ± 0.030	4.030 3.970	3.998	

Plex 10/17/19 9:00 AM Dart.lajeunesse.marie

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev J